

Date: Tuesday, 11/14/2006 10:08:40 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STEP WELDMENT
Job Number :	29412		
Estimate Number :	12577		
P.O. Number :		Part Number :	D3562042
This Issue :	11/14/2006	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3562 REV A
First Issue :	1 / 1	Project Number :	N/A
Previous Run :	29412	Drawing Revision :	A
Written By :		Material :	
Checked & Approved By :		Due Date :	11/24/2006
Comment :	Est Rev:A New Issue 06-11-09 JLM	Qty:	5 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Qty Part # Description Batch:

1 D2622-120C Extrusion 328215

Check Material for any Dents or Defects

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion to 36.45" long as per Dwg D3562

2-Deburr and bevel ends for welding

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

4.0	D2734	206 Step Endplate
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2734 End Cap 329340

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/14/2006 10:08:40 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 29412

Part Number: D3562042

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D35602

ARM



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D35602

Arm

329448

PE. 07.01.02 5

6.0 D35604

ARM



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

ARM

Batch: 329450

PE. 07.01.02 5

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld arms and end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

Use DT8894 To Weld Arms

A/R Aluminum Rod M100237 & M19612

PE. 07.01.03 5

F.F. 07.01.03 = 3

2-Grind end cap welds flush as per Dwg D3562

PE. 07.01.03 = 2

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/01/03 (5)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/03 S

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07-03-01 HJ/gm (5)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Deburr and bevel aft end for welding.

2-Weld as per Dwg D3562

a/r AL ROD Batch: M100237 M19612

PE. 07.01.09 10
PE. 07.01.09 10

(770)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07-01-02	5.0	Part 1's A - 2. permanent change.	FF	07-01-10				
07-01-09	11b.	grind end plate flush	FF	07-01-09	5	QS:WZ	07-01-07	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/14/2006 10:08:40 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 29412

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/01/10 (5)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/10 (5)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

4/ 07/01/11 x5

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COA

Powder Coat Wl

07/01/11 x5

16.0

HAND FINISHING1



Comment: HAND FINISHING

Wing Walk as p

Batch:

07/01/11 (5)

17.0

QC3

AL CONVERSION



Comment: INSPECT POW

18.0

PACKAGING 1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

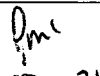

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

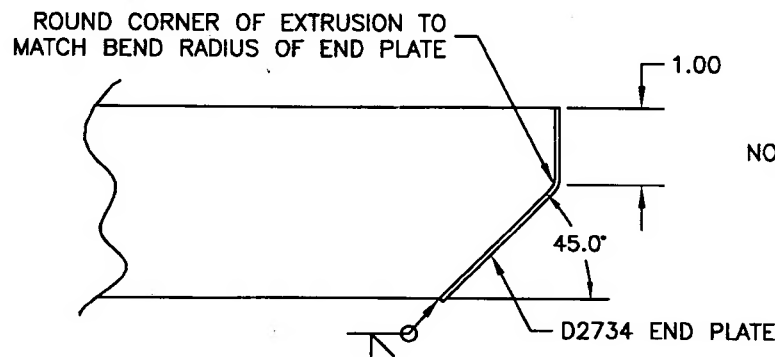
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-01-31		RH steps do not fit - scrap/destroy per Serge/Bull			 07-01-31			

NOTE: Date & initial all entries

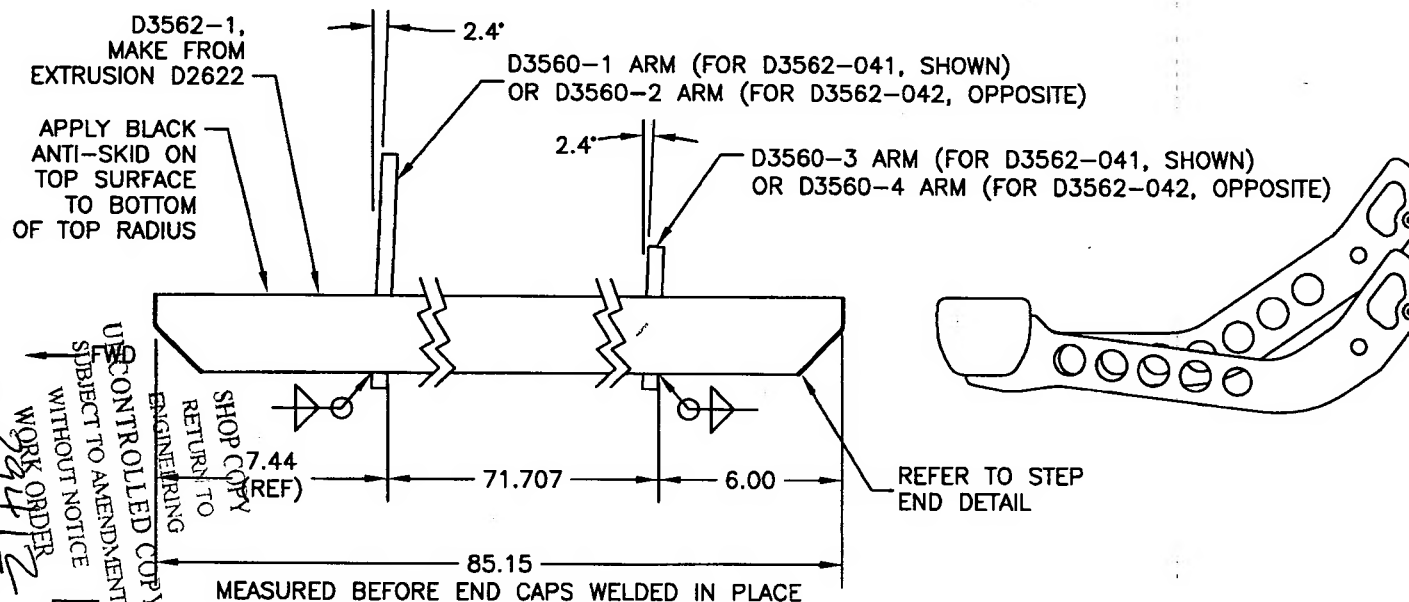
DART

DESIGN	APPROVED	DRAWN BY	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	D3562
DATE	06.09.26	TITLE	STEP WELDMENT
A	06.09.26	NEW ISSUE	NTS
REV. A	SHEET 1 OF 1	SCALE	

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



TYPICAL STEP END DETAIL
NOT TO SCALE



D3562-041 LH STEP ASSEMBLY (SHOWN)
D3562-042 RH STEP ASSEMBLY (OPPOSITE)

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

2.11.07

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WITHOUT NOTICE
WORK ORDER
29412

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